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REV.

DESCRIPTION

DATE

APPROVED

LAST PROTOTYPE REVISION: PR2

NC

N/C

INITIAL RELEASE

10-14-20

J.GARDINER

NOTES:

1.

IDENTIFY IAW MPP-120.

2

DEBURR AND BREAK ALL SHARP EDGES.
45° CHAMFER .015" TO .030" AROUND PART EXTERIOR EDGES.

3

FINISH: BRUSHED.

4

MATERIAL: 301 STAINLESS STEEL PER AMS 5518 11 GA. (.125" THICK).

5

MATERIAL: 301 STAINLESS STEEL PER AMS 5518 16 GA. (.0625 THICK).

6

PRIMER FINISH: PC 4426, VENDOR: ROYAL ADHESIVES & SEALANTS. FOR ASSY'S 652.7001- .7003 APPLY PRIMER AFTER ASSY HAS BEEN ADHERED.

7

REFER TO 652.2300/ 652.2400 FOR DOUBLER HOLE LOCATIONS/ SIZE.

8

LINE TO BE SCRIBED ON FLAT PATTERN.

9

DEBURR AND BREAK ALL SHARP EDGES.
45° CHAMFER .005" TO .010" AROUND PART EXTERIOR EDGE.

10

100% LOT INSPECTION, CRITICAL FEATURE.

11

SCORE SURFACE, BEFORE APPLYING PRIMER, USING 40 GRIT SAND PAPER.

12

ENSURE ALL HOLES ARE CONCENTRIC. ADHERE GIRT STRIPS USING F/N 21. ADHESIVE SHOULD BE AT ROOM TEMP PRIOR TO MIXING. APPY THIN LAYER ACROSS ENTIRE SURFACE AND LET CURE FOR 24 HOURS.

13

VENDOR: RESINLAB. P/N AR4315.

A/R	A/R	A/R	21	600.1000	ADHESIVE		13
1			20	654.7029	GIRT STRIP 4 HOLE	5	3 1 1
	1		19	654.7028	GIRT STRIP 3 HOLE	5	3 1 1
		1	18	654.7027	GIRT STRIP 2 HOLE	5	3 1 1
			17	654.7026	FLANGE DOUBLER (AFT)	5	3 6 1
			16	654.7025	RIGHT HAND 3RD DOUBLER (FWD)	5	3 6 1
			15	654.7024	LEFT HAND 3RD DOUBLER (FWD)	5	3 6 1
			14	654.7023	RIGHT HAND 2ND DOUBLER (FWD)	5	3 6 1
			13	654.7022	LEFT HAND 2ND DOUBLER (FWD)	5	3 6 1
			12	654.7021	RIGHT HAND 1ST DOUBLER (FWD)	5	3 6 1
			11	654.7020	LEFT HAND 1ST DOUBLER (FWD)	5	3 6 1
			10	654.7019	5 HOLE DOUBLER (AFT)	5	3 6 1
			9	654.7018	4 HOLE DOUBLER (AFT)	5	3 6 1
			8	654.7017	2 HOLE DOUBLER (AFT)	5	3 6 1
	1		7	654.7016	GIRT STRIP 3 HOLE	5	3 1 1
		1	6	654.7015	GIRT STRIP 2 HOLE	5	3 1 1
			5	654.7014	GIRT STRIP 4 HOLE	4	3 6 1
			4	654.7013	GIRT STRIP 5 HOLE	4	3 6 1
			3	654.7012	GIRT STRIP 6 HOLE	4	3 6 1
			2	654.7011	GIRT STRIP 5 HOLE	4	3 6 1
1			1	654.7010	GIRT STRIP 4 HOLE	4	3 1 1
X				654.7003	FWD GIRT ASSY 4 HOLE		6 1 2
	X			654.7002	FWD GIRT ASSY 3 HOLE		6 1 2
		X		654.7001	AFT GIRT ASSY 2 HOLE		6 1 2
.7003	.7002	.7001	FIND #	PART #	DESCRIPTION	MAT'L	SPEC

QTY

NEXT ASSY (S)

651.7600

ORIGINAL DATE (MO-DA-YR)

20.10.14

DRAWN BY

CHECKER

EC

P. BRAVO

DRAWING APPROVAL

J. GARDINER

20.10.14

CONTRACT No.

UNLESS OTHERWISE SPECIFIED

DIMENSIONS ARE IN INCHES

TOLERANCES ARE:

2 PLACE DECIMALS ±.01

3 PLACE DECIMALS ±.005

ANGLES ± .5°

DART

AEROSPACE

APICAL INDUSTRIES, INC.

dba DART AEROSPACE

3030 ENTERPRISE CT.,

SUITE A

VISTA, CA. 92081

(760)-724-5300

AW169 GIRT BARS AND DOUBLERS

SIZE

B

CAGE CODE

07MZ6

DWG. NO.

654.7000

REV.

N/C

SCALE NONE

SHEET 1 OF 10

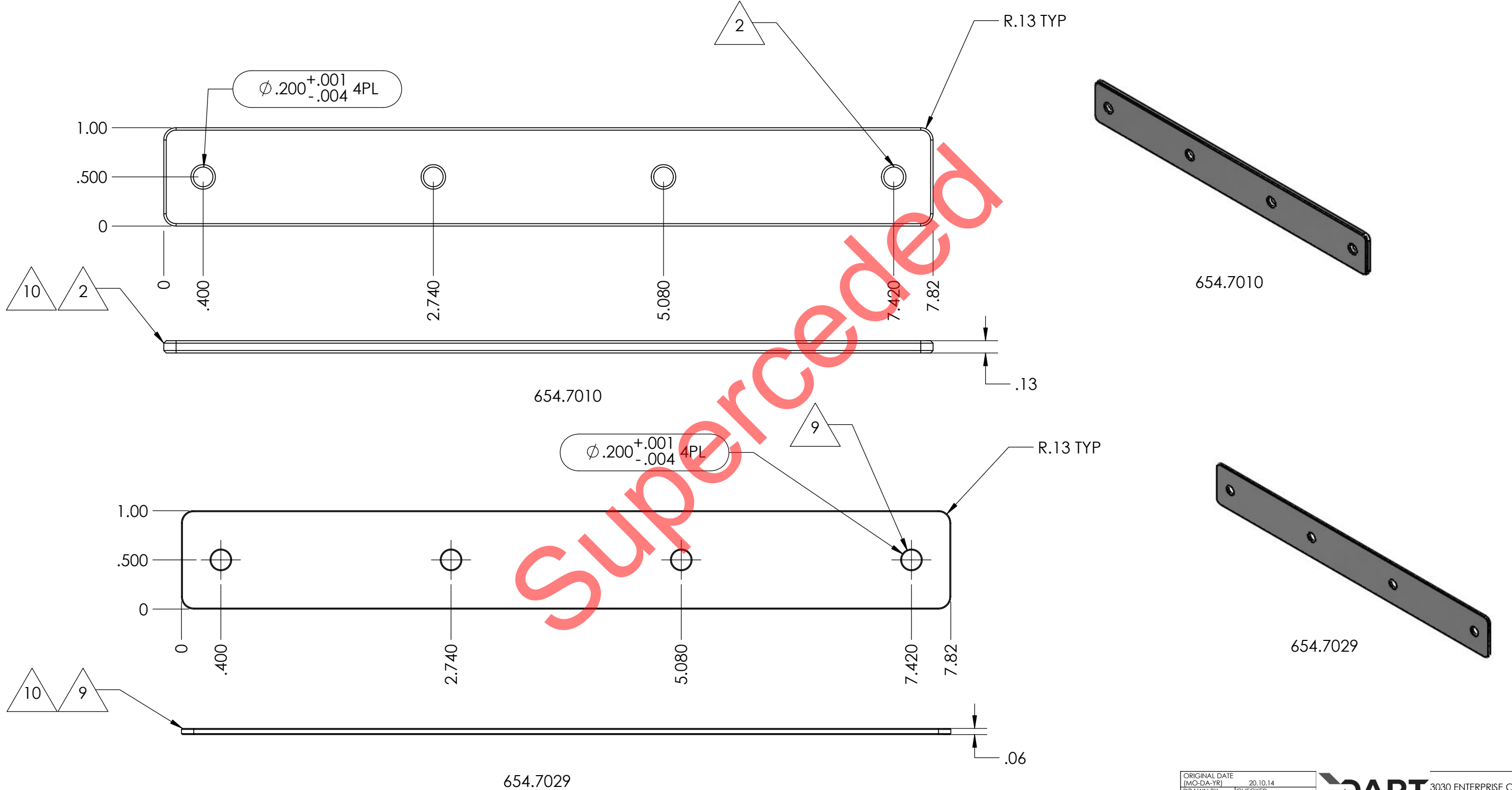
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A

B

C

D



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DRAWN BY EC	CHECKER P. BRAVO				
DRAWING APPROVAL P. BRAVO 20.10.14		AW169 GIRT BARS AND DOUBLERS			
CONTRACT No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS $\pm .01$ 3 PLACE DECIMALS $\pm .005$ ANGLES $\pm .5^\circ$		SIZE	CAGE CODE	DWG. NO.	REV.
		B	07MZ6	654.7000	N/C
		SCALE NONE		SHEET 2 OF 10	

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A

B

C

D

.10 X 45°
2 PL

1.00
.500
0

$\phi .200^{+.001}_{-.004}$ 5 PL

R.13
2 PL

0

.500

2.607

4.714

6.989

9.337

9.84

654.7011

.13

654.7011

.10 X 45°
2 PL

1.00
.500
0

$\phi .200^{+.001}_{-.004}$ 6 PL

R.13
2 PL

0

.500

2.848

5.105

7.362

9.620

11.877

12.38

654.7012

.13

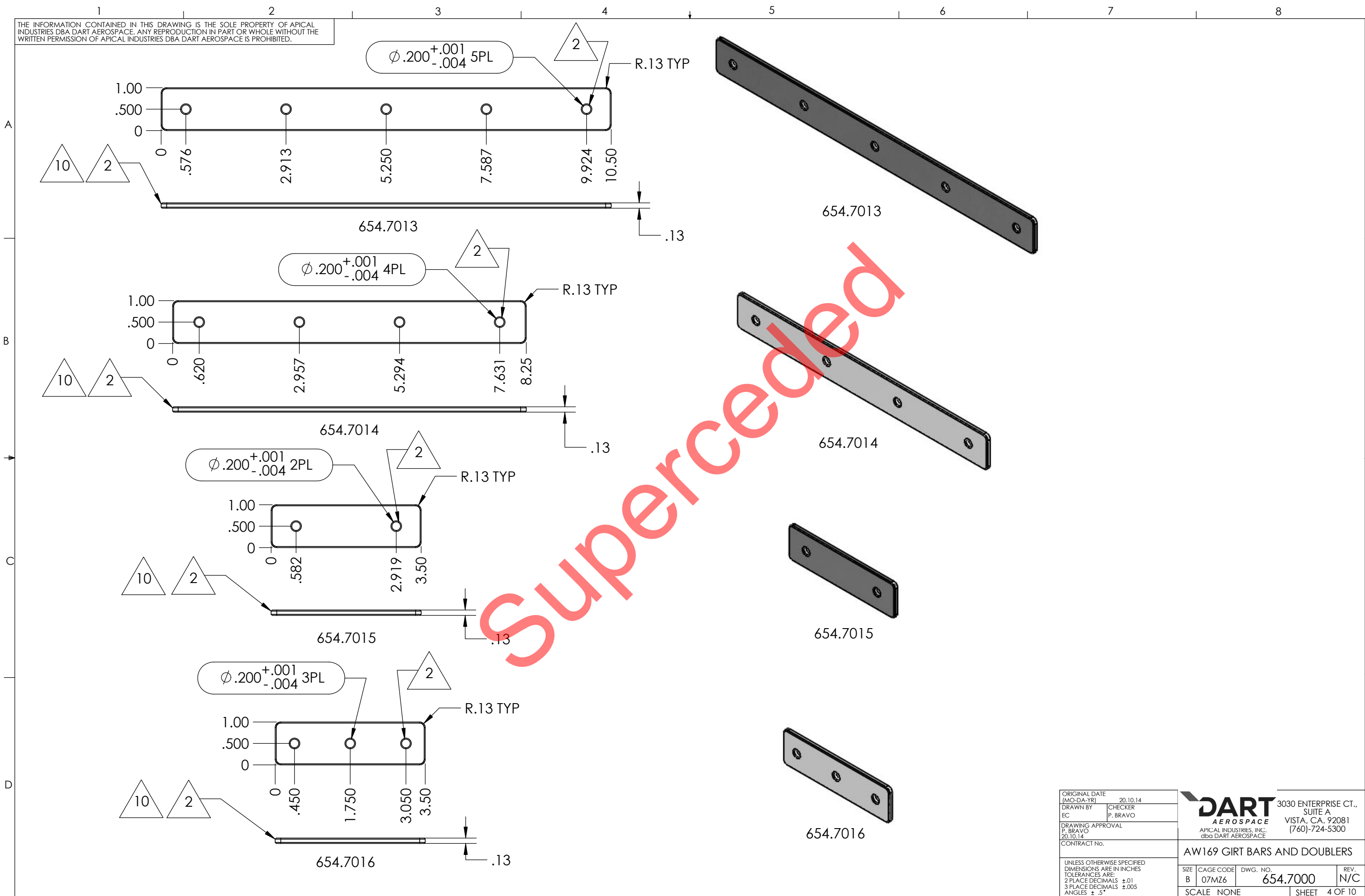
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ANGLES $\pm .5^\circ$

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AW169 GIRT BARS AND DOUBLERS			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 654.7000	REV. N/C
SCALE NONE		SHEET 3 OF 10	

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(760)-724-5300

AW169 GIRT BARS AND DOUBLERS

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SCALE NONE		SHEET 4 OF 10	

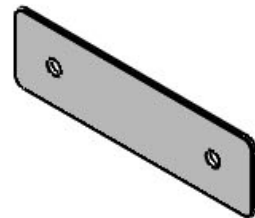
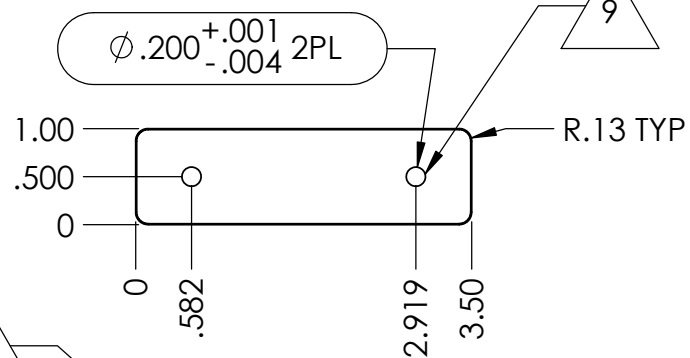
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A

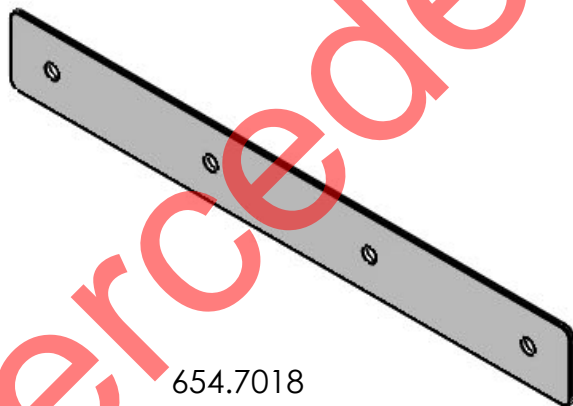
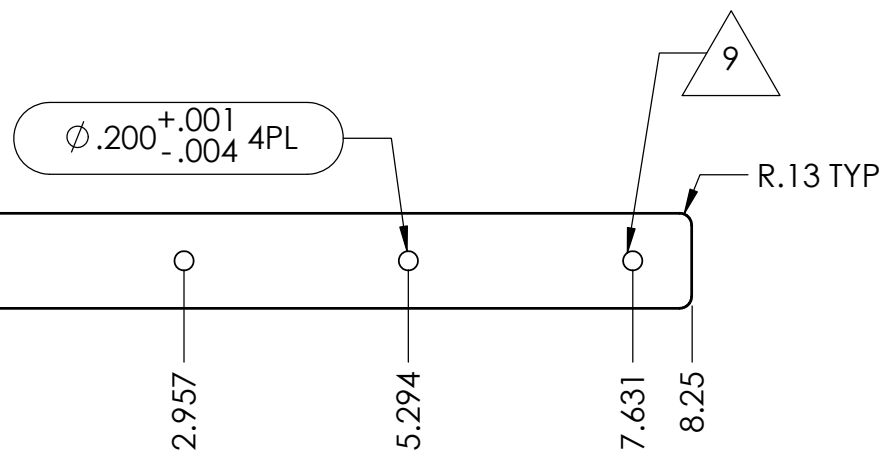
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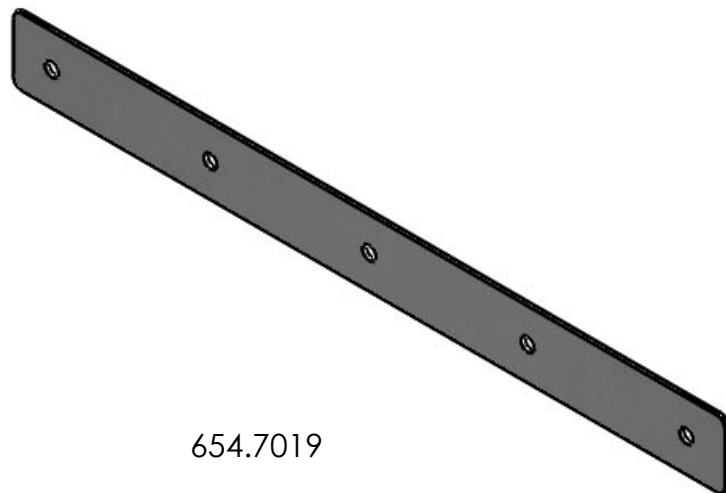
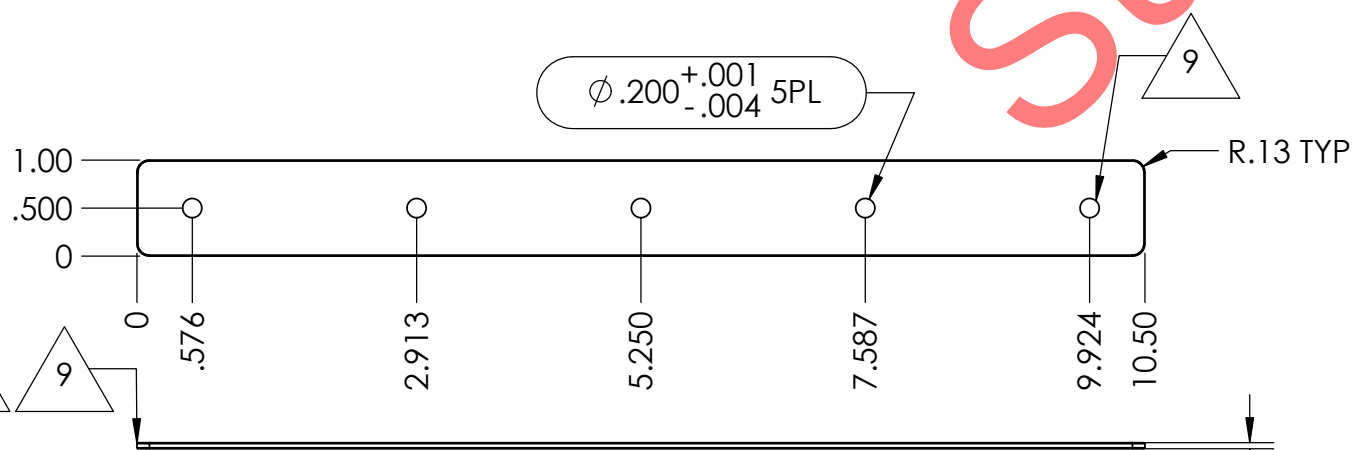
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654.7017



654.7018



654.7019

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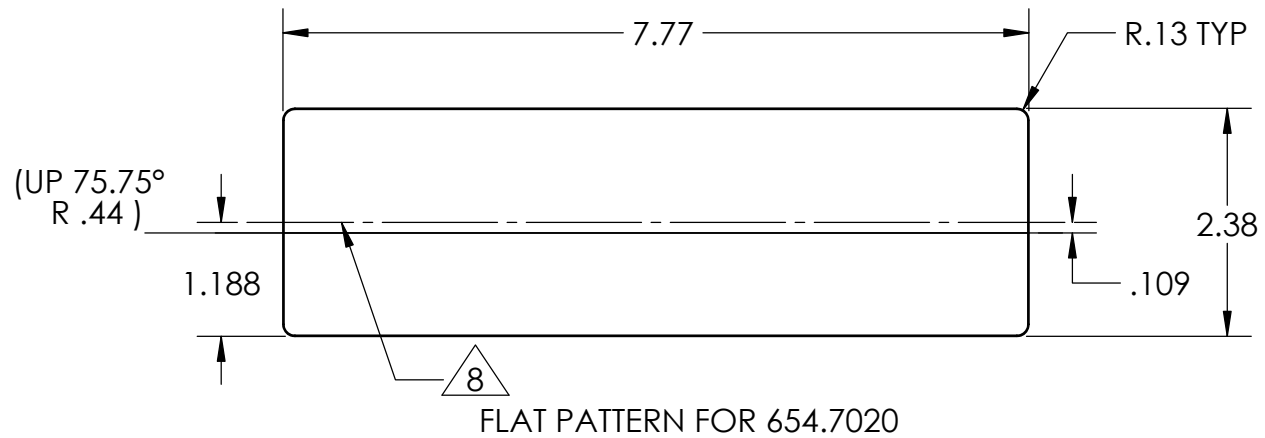
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AW169 GIRT BARS AND DOUBLERS

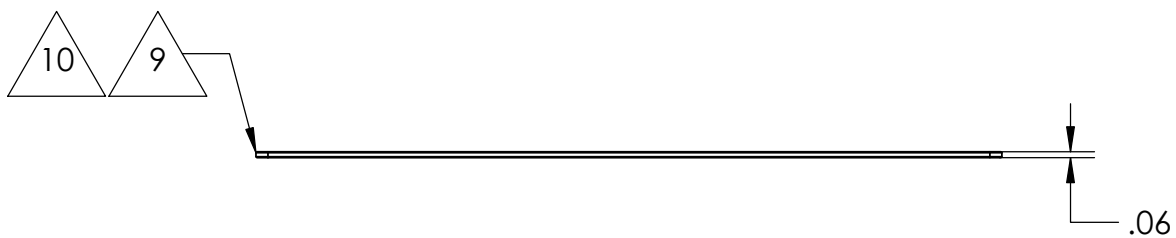
SIZE B	CAGE CODE 07MZ6	DWG. NO. 654.7000	REV. N/C
SCALE NONE		SHEET 5 OF 10	

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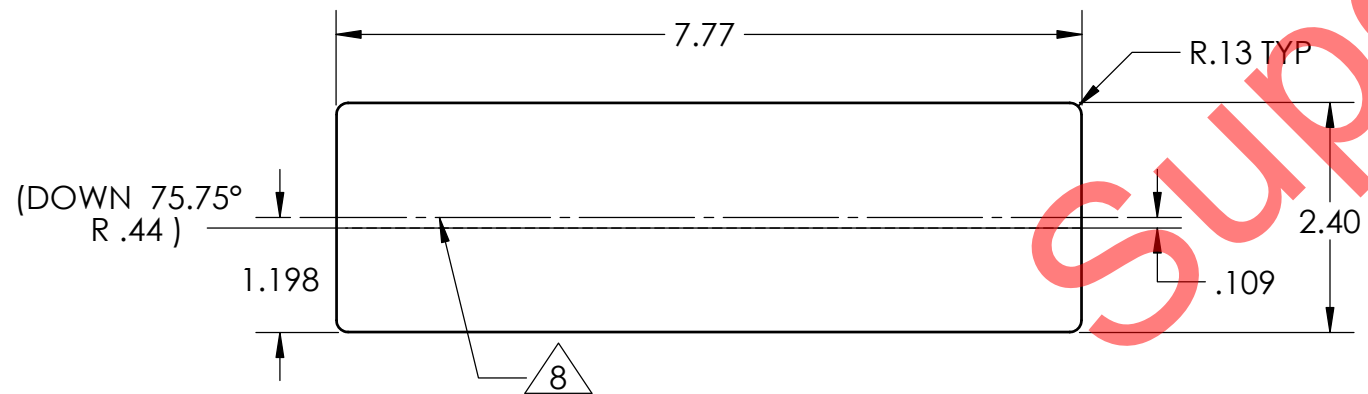
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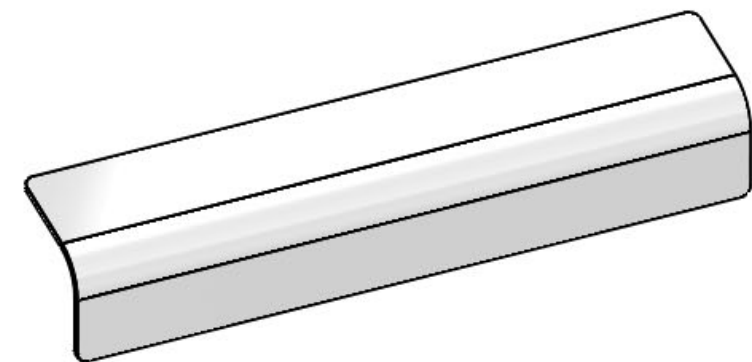
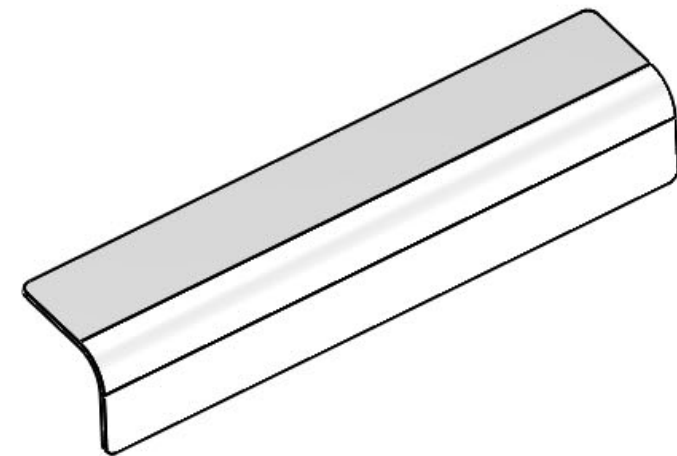
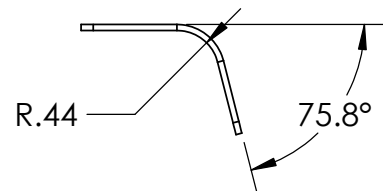
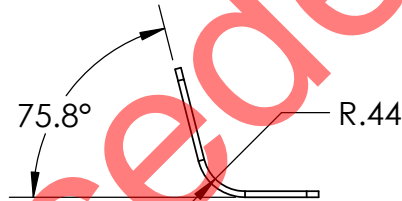
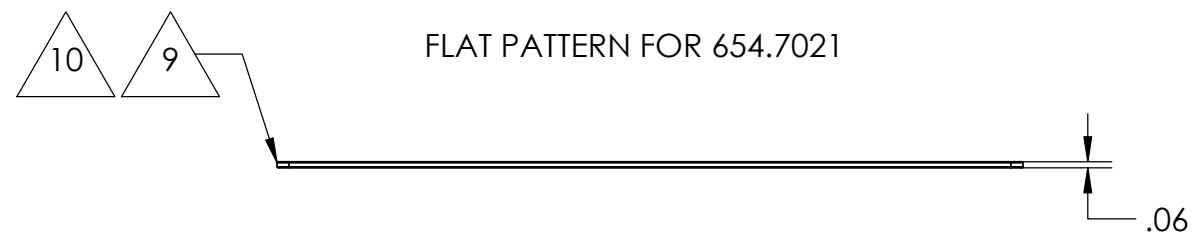
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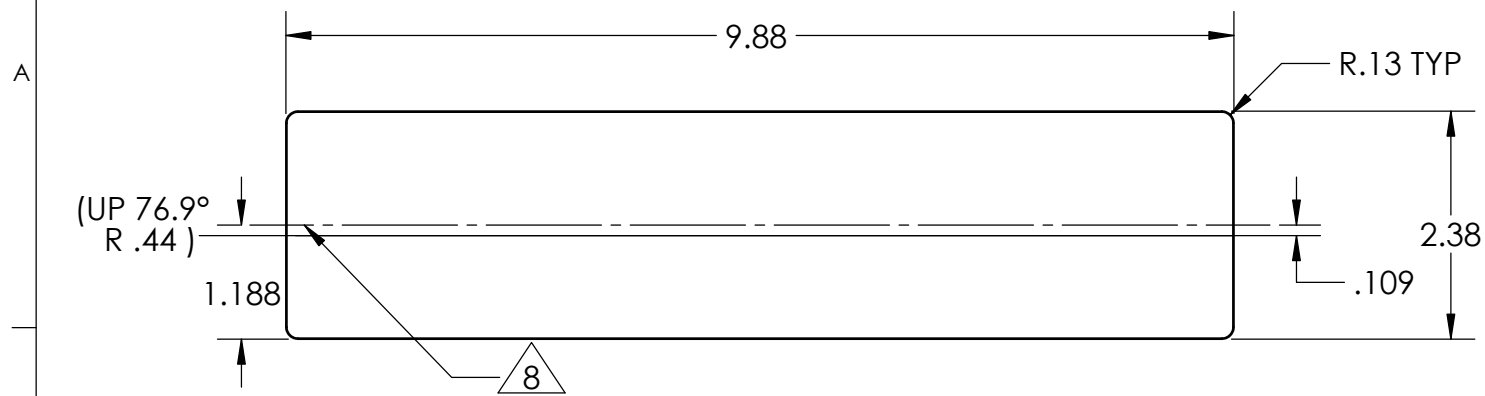


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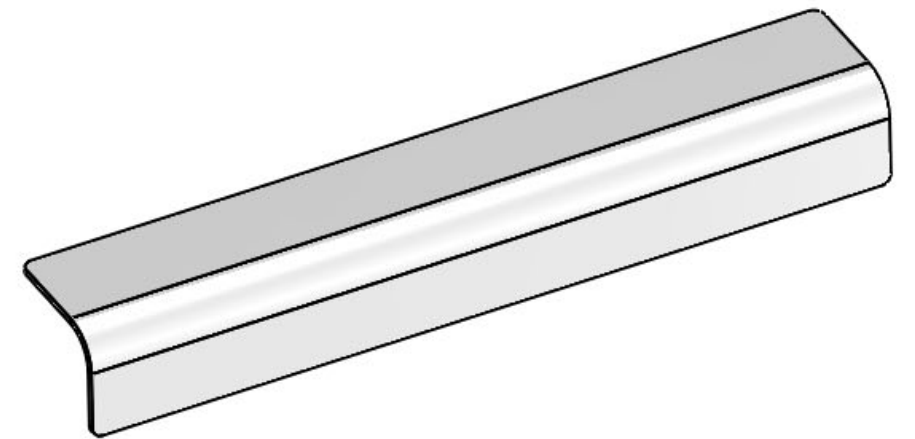
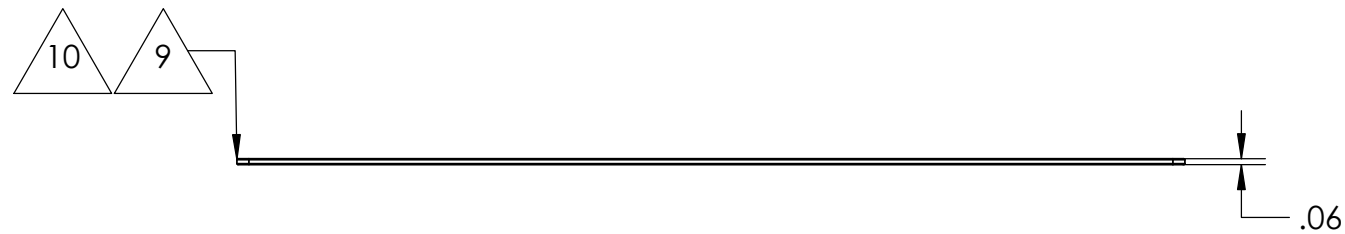
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AW169 GIRT BARS AND DOUBLERS			
SIZE B	CAGE CODE 07MZ6	DWG. NO. 654.7000	REV. N/C
SCALE NONE		SHEET 6 OF 10	

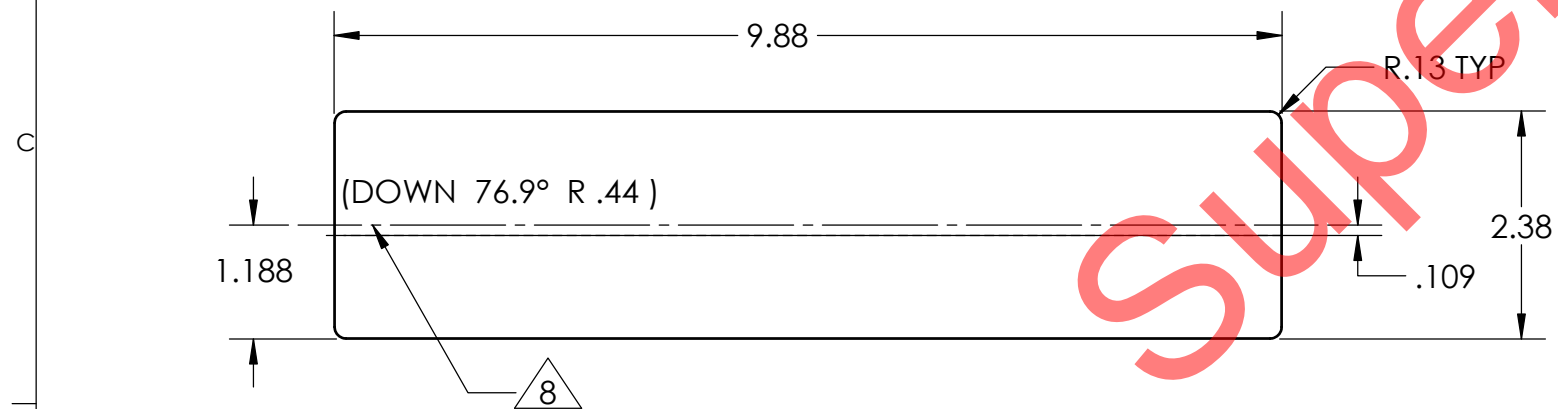
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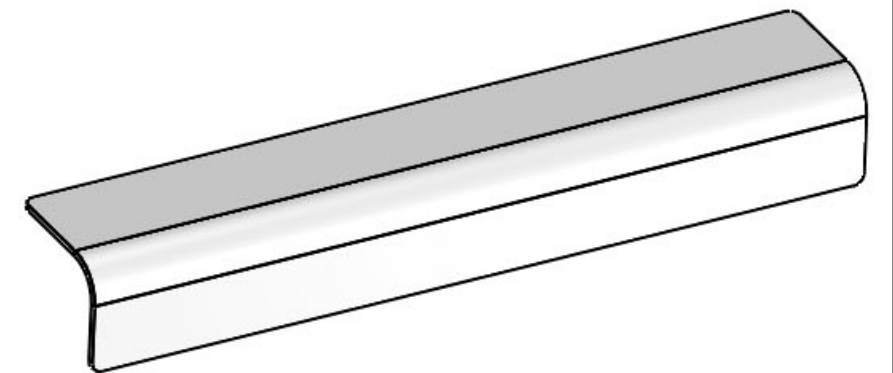
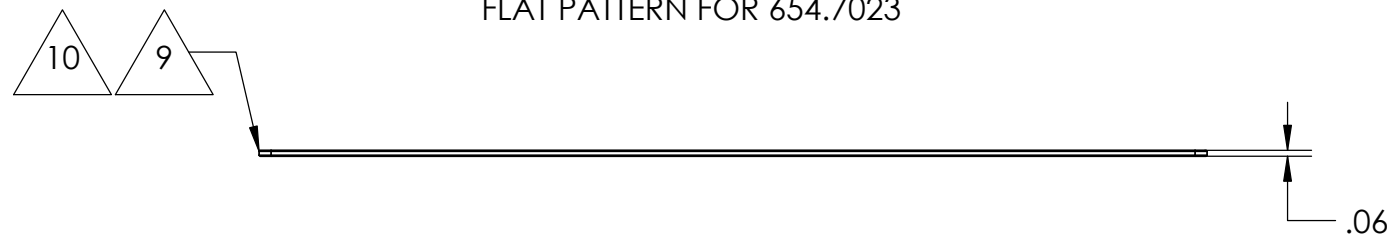
FLAT PATTERN FOR 654.7022



654.7022 7



FLAT PATTERN FOR 654.7023



654.7023 7

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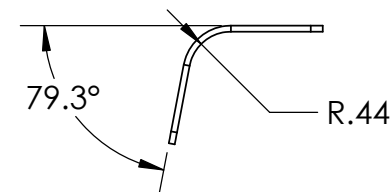
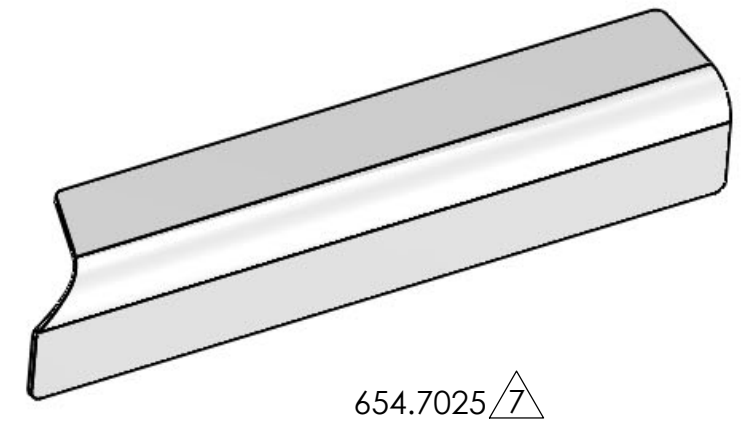
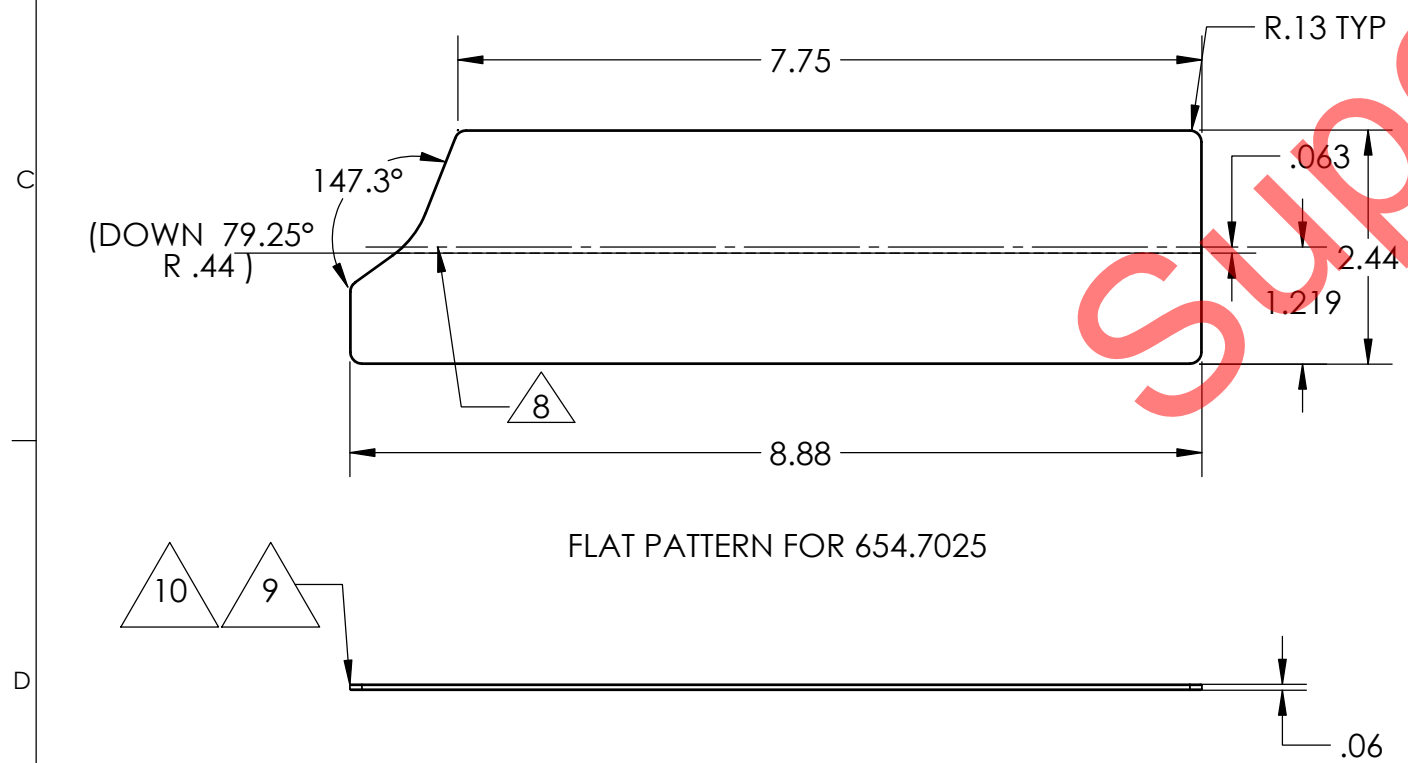
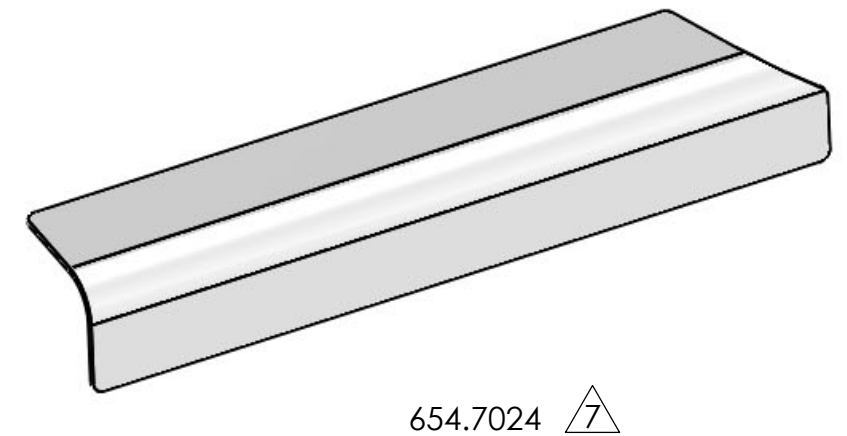
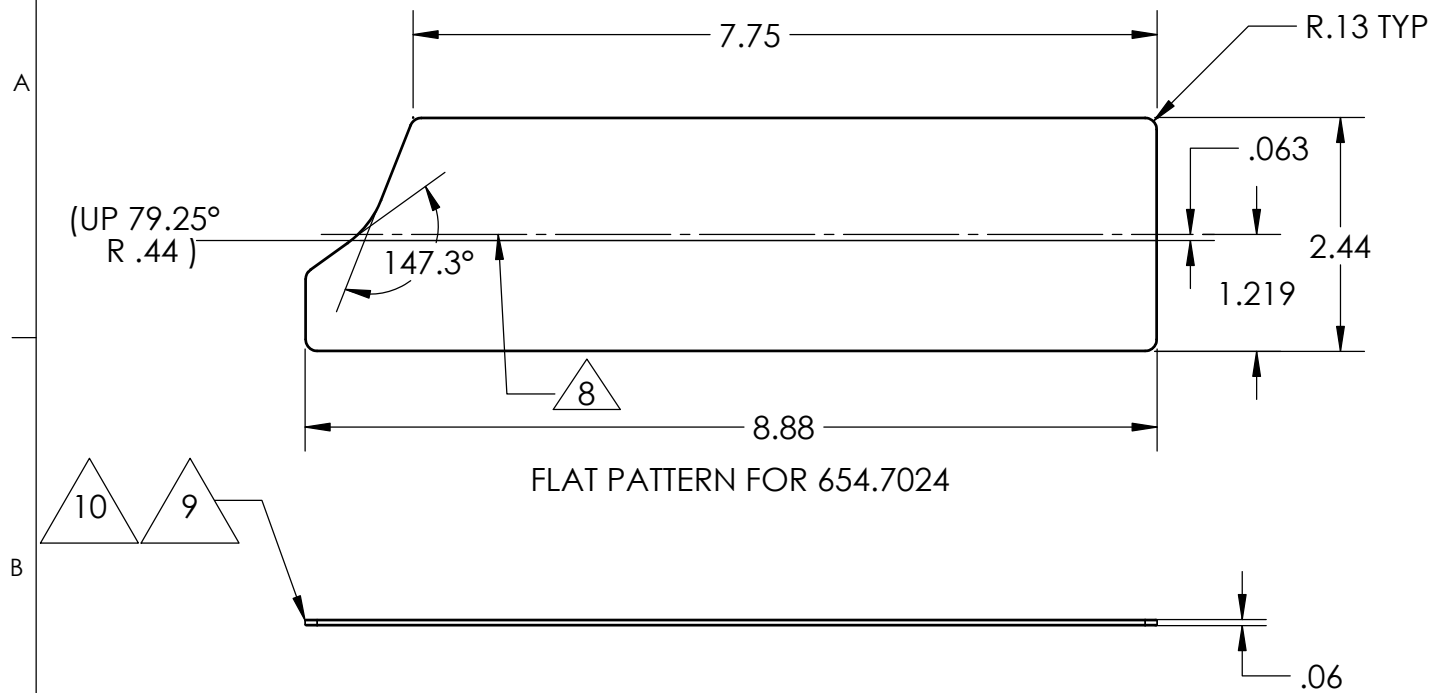
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3 PLACE DECIMALS ±.005
ANGLES ± .5°

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APICAL INDUSTRIES, INC. dba DART AEROSPACE		

AW169 GIRT BARS AND DOUBLERS

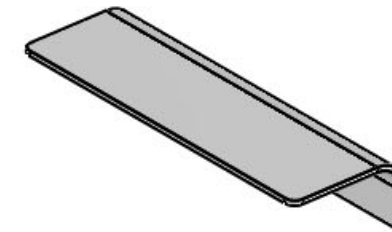
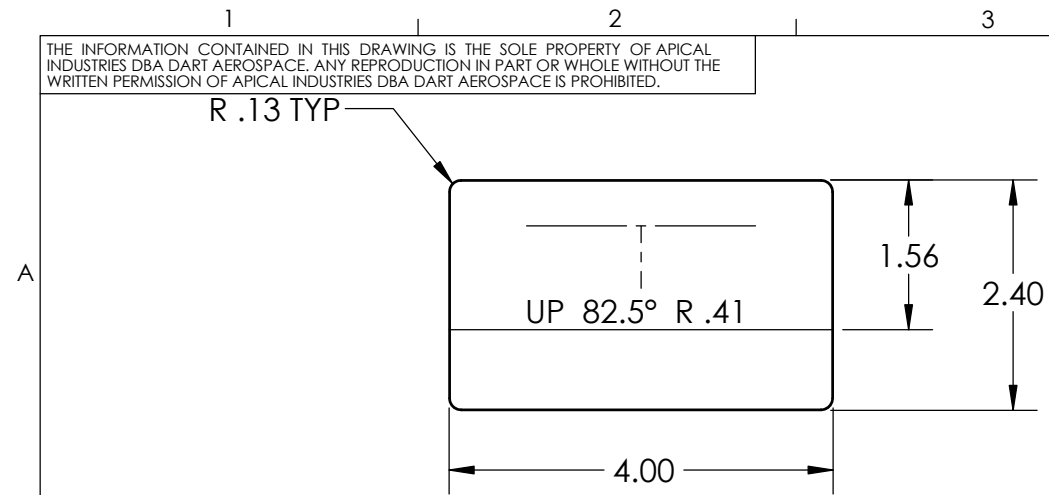
SIZE B	CAGE CODE 07MZ6	DWG. NO. 654.7000	REV. N/C
SCALE NONE			SHEET 7 OF 10

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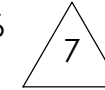


ORIGINAL DATE (MO-DA-YR) 20.10.14		3030 ENTERPRISE CT., SUITE A	
DRAWN BY EC	CHECKER P. BRAVO	VISTA, CA. 92081 (760)-724-5300	
DRAWING APPROVAL P. BRAVO 20.10.14		AW169 GIRT BARS AND DOUBLERS	
CONTRACT No.		SIZE B	REV. N/C
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		SCALE NONE	SHEET 8 OF 10

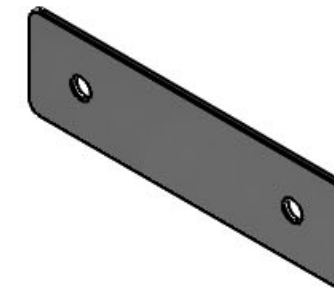
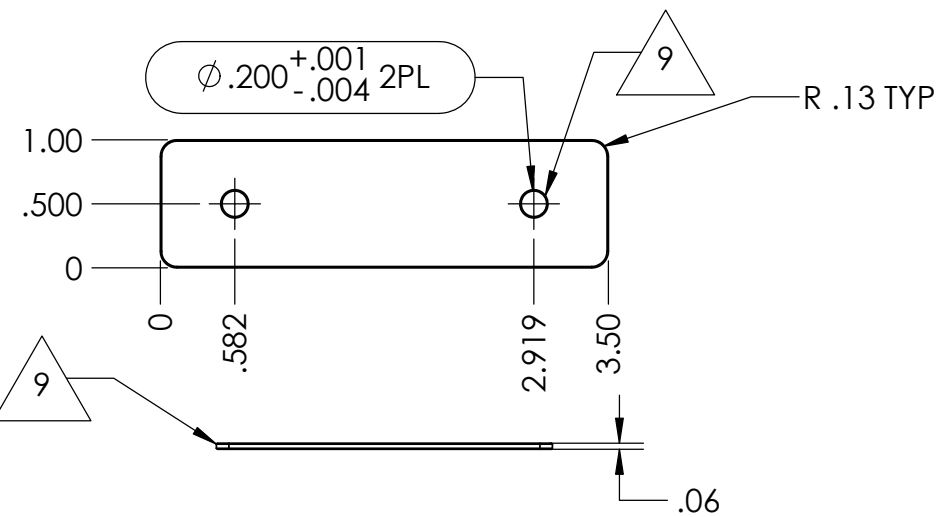
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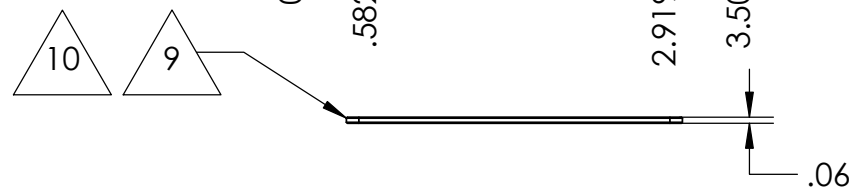
654.7026



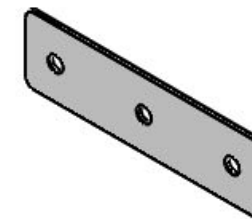
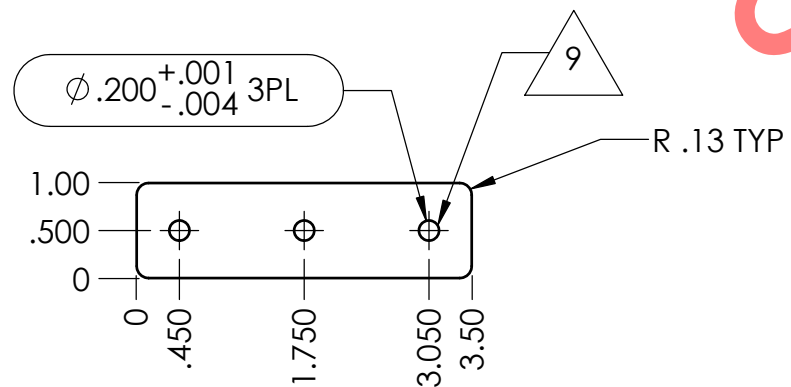
FLAT PATTERN FOR 654.7026



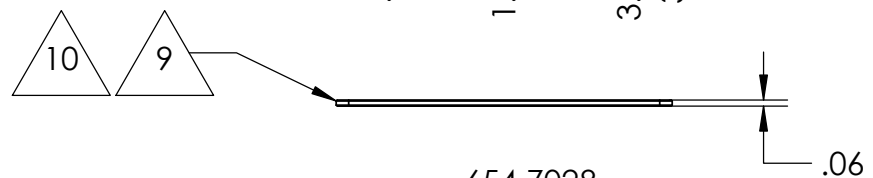
654.7027



654.7027



654.7028



654.7028

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		SCALE NONE		SHEET	9 OF 10

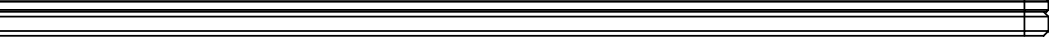
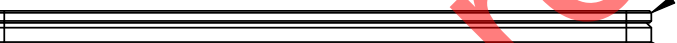
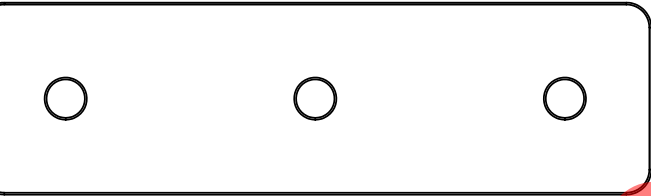
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654.7001

654.7002

654.7003

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AW169 GIRT BARS AND DOUBLERS

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